

Thursday, 31/07/2008 12:19:00 PM
Julie Leach

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : N1 GEARBOX ACCESS PANEL KIT

Part Number : 40858

Estimate Number : 12505

S.O. Number :

This Issue : 31/07/2008

S.O. No. :

First Rev. : NC

First Issue : 11

Previous Run : 37429

Type : SMALL / MED FAB

Part Number : D412705017

Drawing Number : D3255 REV B

Project Number : N/A

Drawing Revision : B

Material :

Due Date : 07/08/2008

Qty: 1

Um: Each

Written By :

Checked & Approved By :

Document :

Est Rev:C Removed Manufacturing 06-08-02 JLM

Est Rev:D ECN 1052 07-11-06 DD verified by: EC

Additional Product

Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



JLD 08-8-11

50810116

Comment: Photocopy bluefile & type labels per PPPD412-705-017

CHG001

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D3255041

Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Access Panel Assembly

Batch: B33603

B40903 14

4.0

D3255042

Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Access Panel Assembly

Batch: B33604

B40904 14

5.0

AN3C3A

Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total: 60.0000 Each(s)

Bolt

Batch: M108521

M108821

8/8/08

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 40858

Part Number: D412705017

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	MS20427M33	Rivet
-----	------------	-------



Comment: Qty.: 36.0000 Each(s)/Unit Total : 72.0000 Each(s)

Rivet

Batch: M108473

SP

7.0	MS21060L3K	Nut Plate
-----	------------	-----------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 36.0000 Each(s)

Nut Plate

Batch: M107519

M108521

M108827

SP

8.0	MS932109	Washer
-----	----------	--------



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Batch: M108580

M108521

M108827

SP

QC4 INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/09/16

10.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 0412-705-017

Location:

PPP Rev:

Rev A

08/09/16

11.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

08/09/16

Completion:

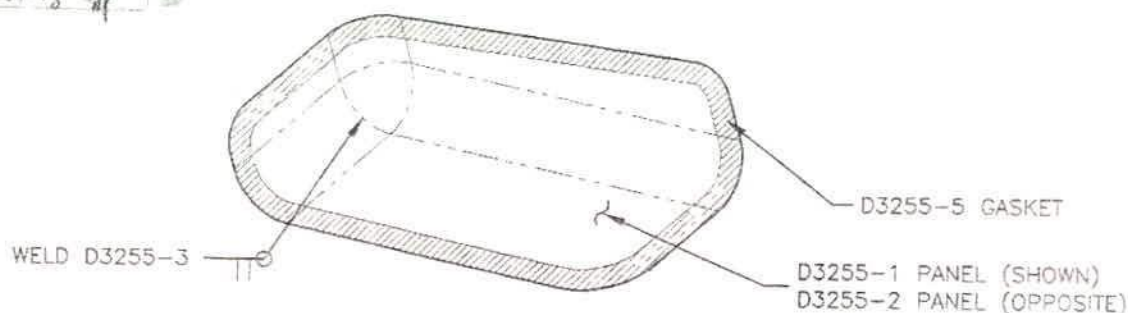


MF 08-09-16

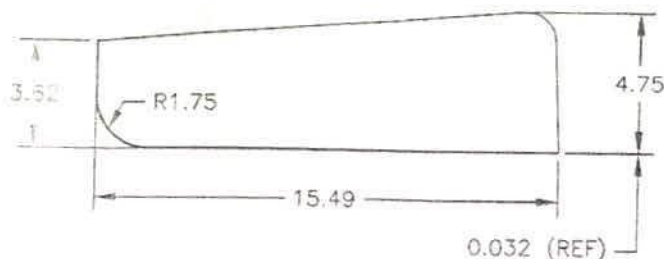
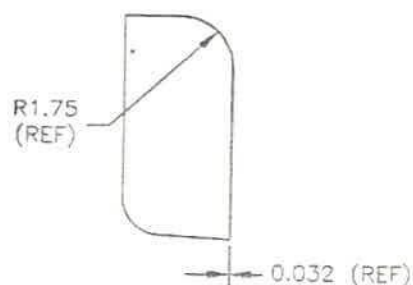
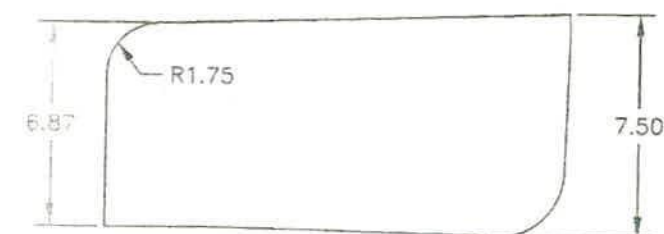
DART

RELEASED
05-01-18 #

DESIGN R	DRAWN BY R	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:1
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

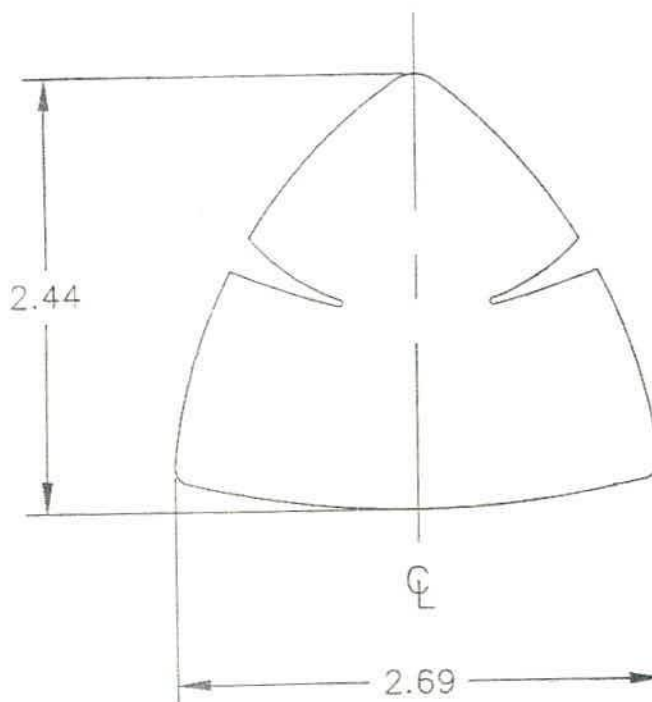
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 10558

DART

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06	TITLE TITLE		SCALE 1:1

RELEASED
05-01-08 JF



D3255-3 CAP
FORM TO FIT D3155-1/-2

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40858

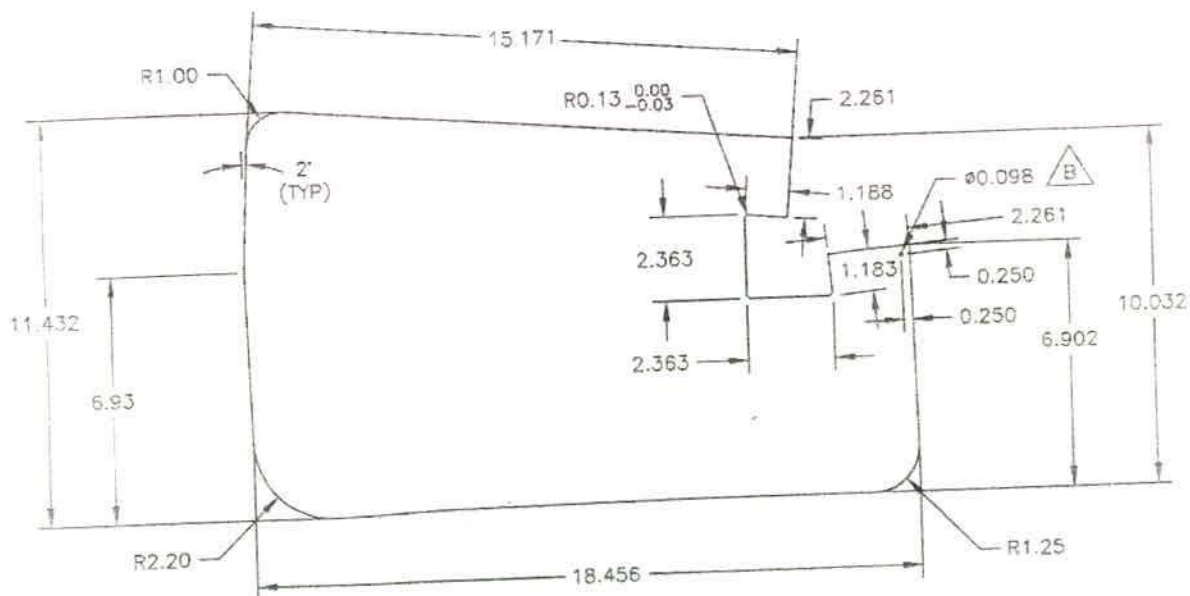
D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. CE 501

D3255-1/-2 NOTES:

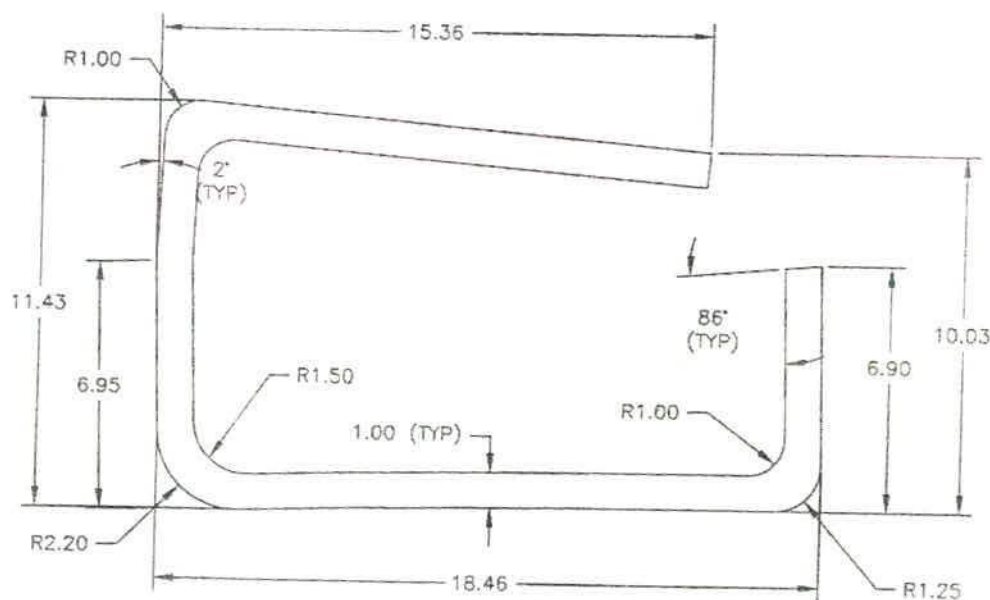
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:5

RELEASED
05 01.18 JF**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART OSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 418508

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.